

Work Order ID 82173

Friday, March 23, 2012 1:29:55 PM

82173

Page 1

Item ID: K10111

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date: 2-03-23

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9583

A

K10111

B

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP
FOR D206-642-111 CHG007
FOR D206-642-113 CHG002

K10111 CHG003

JB Schulz

JB Schulz 12-4-12
(4)

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

4 *12/04/11 JB*
JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

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Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP

K10111

PPP D206-642-111

PPP D206-642-113

Location:

PPP rev:

PAG 13

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

(74) 1/4/12

12/4/12

12-04-12

W/O: _____		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 82173

82173

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: F01.11.08 Revised Step 5 and Added Inspection Level
21SM IPP REV:G
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-41A		Purchased	No			110	Each	435.0000	8	32			
<div> <div>S</div> <div>*AN3-41A*</div> <div>Bolt</div> </div>													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST335</div> <div>235</div> <div></div> </div>													
<div> <div>120644</div> <div>235</div> <div></div> </div>													
<div> <div>ST354</div> <div>200</div> <div></div> </div>													
<div> <div>120498</div> <div>200</div> <div></div> </div>													
AN4-6A		Purchased	No			110	Each	1,515.0000	12	48			
<div> <div>S</div> <div>*AN4-6A*</div> <div>Bolt</div> </div>													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST356</div> <div>1515</div> <div></div> </div>													
<div> <div>119017</div> <div>1515</div> <div></div> </div>													
AN4C5A		Purchased	No			110	Each	256.0000	1	4			
<div> <div>S</div> <div>*AN4C5A*</div> <div>BOLT</div> </div>													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>ST355</div> <div>256</div> <div></div> </div>													
<div> <div>112243</div> <div>156</div> <div></div> </div>													
<div> <div>119017</div> <div>100</div> <div></div> </div>													

JB GP

120644

JB GP

119017

JB GP 12/04/11

119017

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

Page 2

Friday, March 23, 2012 1:30:00 PM

Work Order ID: 82173

82173

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 4.00

Required Qty: 4.00

AN5-10A Purchased No

110 Each 358.0000 4 16

**

AN5-10A

Bolt

Location

Loc Qty

Loc Code

ST337

358

118191

80

120630

30

120717

50

120770

198

120770

AN5-11A Purchased No

110 Each 733.0000 4 16

**

AN5-11A

Bolt

Location

Loc Qty

Loc Code

ST337

733

118191

13

119512

720

119512

AN6-44A Purchased No

110 Each 105.0000 2 8

**

AN6-44A

Bolt

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

98

119036

98

119036

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, March 23, 2012 1:30:01 PM

Work Order ID: 82173

82173

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 4.00

Required Qty: 4.00

D206-651-041

Manufactured No

110

Each

20.0000

1

4

**

D206-651-041

206A/B GHW

Location

Loc Qty

Loc Code

FG120

10

79558

10

FG125

10

81288

10

110

Each

628.0000

16

64

**

D2652

Manufactured No

D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

584

73834

15

73836

36

76134

1

76136

55

77134

400

77136

77

110

Each

16.0000

2

8

**

D2661-1

Manufactured No

D2661-1

Saddle, LH Fwd Aft Out 206

Location

Loc Qty

Loc Code

MEZZ

7

64559

5

76730

2

ST434

9

80412

9

Friday, March 23, 2012 1:30:01 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Friday, March 23, 2012 1:30:01 PM

Work Order ID: 82173

82173

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 4.00

Required Qty: 4.00

D2662-1 Manufactured No

110 Each 12.0000 2 8 ✓

**

JB [initials]

D2662-1

Saddle, LH In 206

Location

Loc Qty

Loc Code

ST435

12

80414

12

80414

D2712 Manufactured No

110 Each 962.0000 10 40 ✓

**

JB [initials]

D2712

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

700

79585

500

81871

200

79585

ST021

212

76065

212

D2884 Manufactured No

110 Each 123.0000 2 8 ✓

**

JB [initials] 12/04/11

D2884

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST020

113

76751

113

76751

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, March 23, 2012 1:30:01 PM

Work Order ID: 82173

82173

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 4.00

Required Qty: 4.00

D2885

Manufactured No

110

Each

114.0000

2

8

**

JB

S ***D2885***

M Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST020

104

76752

104

76752

D3413-1

Manufactured No

110

Each

72.0000

**

4

JB

S ***D3413-1***

M Ring

Location

Loc Qty

Loc Code

ST420

17

70773

1

79233

16

ST464

55

76754

33

80224

22

76754

MS21042L3

Purchased No

110

Each

2,835.000

8

32

**

JB 12/04/11

S ***MS21042L3***

M Nut

Location

Loc Qty

Loc Code

ST300

2835

117441

16

117885

32

118451

5

118927

3

119017

2613

119075

166

119017

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Friday, March 23, 2012 1:30:01 PM

Work Order ID: 82173

82173

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L4 Purchased No

110 Each 4,785.000 12 48 ✓

MS21042L 4

**

Nut

Location

Loc Qty

Loc Code

ST300

4785

119017

14

119075

2771

121011

2000

119075

MS21042L6 Purchased No

110 Each 926.0000 2 8 ✓

MS21042L 6

**

Nut

Location

Loc Qty

Loc Code

ST300

926

117677

25

118384

3

118927

48

119075

650

120308

200

119075

NAS1149C0463R Purchased No

110 Each 1,018.000 1 4 ✓

NAS1149C0463R

**

Washer

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

1017

117735

46

119097

971

119097

12/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Friday, March 23, 2012 1:30:02 PM

Work Order ID: 82173

82173

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

1,417.000

8

32

NAS1149D0363.I

Washer

**

121243 JB [initials]

Location

Loc Qty

Loc Code

ST298

1417

117601

61

118077

1

118612

18

119537

33

120142

134

120308

162

120644

1000

120986

8

NAS1149D0463J

Purchased

No

110

Each

1,948.000

24

96

NAS1149D0463.I

Washer

**

121255 JB [initials]

Location

Loc Qty

Loc Code

ST297

1787

121011

1787

ST298

161

116805

0

118384

16

119097

145

NAS1149D0563J

Purchased

No

110

Each

2,892.000

8

32

NAS1149D0563.I

Washer

**

JB [initials] 12/04/11

Location

Loc Qty

Loc Code

ST298

2892

118206

19

118614

456

119546

2000

119717

417

118614

Friday, March 23, 2012 1:30:02 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Friday, March 23, 2012 1:30:02 PM

Work Order ID: 82173

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Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0663J

Purchased

No

110

Each

658.0000

4

16

**

NAS1149D0663.I

Washer

Location

Loc Qty

Loc Code

ST298

658

119075

158

120644

500

120644

JB 12/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>AP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BE</i>	K10111	SHEET 1 OF 1
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	SADDLE KIT	NTS
DATE	11.11.10	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	